

**Work Order ID 64815**

Friday, December 17, 2010 8:00:37 AM



Page 1

Item ID: D3204-041

Accept



Setup Start



Revision ID:

Item Name: Release Pedal Assembly

Stop



Start Date: 12/16/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 1/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-12-17 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3204

Rev A1

100



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1- Weld assembly as per Dwg D3204 using Jig D3204-041T1.  2- Drill #40 diameter hole in the center of Ø0.760" cbore on D3204-5 arm prior to weld.  3- Use JB weld compound to plug the hole after assembly.  4- Grind JB weld flush after it is cured.  Ident

R 11-3-10 (44)

110



QC

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

4 0 2011/03/14

120



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 03/14

(44) \_\_\_\_\_

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Date:

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CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

4/26/11 03/14

Hand Finishing

Memo

0.00

140



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 11/12/8.

Memo

0.00

4/26/11 03/15

Powder Coating

\*\*\*Cover holes for bushing\*\*\*  START TIME:3:15  OVEN TEMPERATURE: 620  FINISH

TIME: 3:45

150



QC3- Inspect Part Finish

0.00

4/26/11 03/16

Memo

0.00

Quality Control

QC

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Install D3204-7 bushing as shown in Dwg D3204

170



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location G A

0.00

Packaging

Memo

0.00

Packaging

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

190



QC

Quality Control

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/16

11-03-16

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# Picklist Print

Friday, December 17, 2010 8:00:42 AM

Page 1

Work Order ID: 64815



Parent Item: D3204-041



Parent Item Name: Release Pedal Assembly

Start Date: 12/16/2010

Required Date: 1/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP:  C  05.08.11  Added Step 25  KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1 		Manufactured	No			100	Each	6.0000	1	4			

Tube   
EL 11-2-10

Location	Loc Qty	Loc Code
WA	5	
	5	
WA20	1	
	1	

D3204-11 		Manufactured	No			100	Each	40.0000	1	4			
--------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Plate   
EL 11-3-10

Location	Loc Qty	Loc Code
ST45	14	
	14	
WA	26	
	26	

D3204-3 		Manufactured	No			100	Each	5.0000	1	4			
-------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Arm   
EL 11-3-10

Location	Loc Qty	Loc Code
WA	5	
	5	

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item: D3204-041



Parent Item Name: Release Pedal Assembly

Start Date: 12/16/2010

Required Date: 1/21/2011

Start Qty: 4.00

Required Qty: 4.00

D3204-5



Arm

Manufactured No

7

100

Each

4.0000

1

4



EL 11-3-10

D3204-7



Bushing

Manufactured No

WA  
57738

100

Each

21.0000

2



4  
EL 103/16

D3204-9



Pedal

Manufactured No

ST041

100

Each

7.0000

1

4



EL 11-3-10

D3204-13



Gusset

Manufactured No

WA  
43765  
WA020  
60884

160

Each

21.0000

2



3  
EL 11-3-10.

W/O:		WORK ORDER CHANGES					
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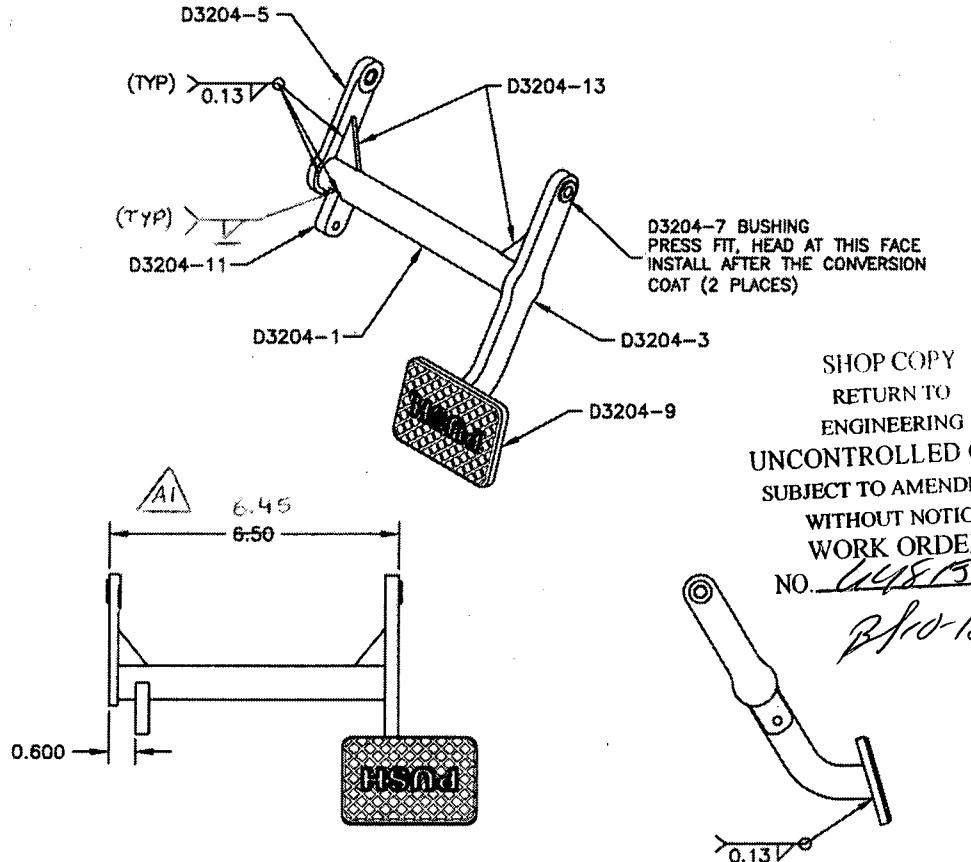
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3204	SHEET 1 OF 3
DATE		TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED  
04.04.30



### D3204-041 RELEASE PEDAL ASSEMBLY

#### NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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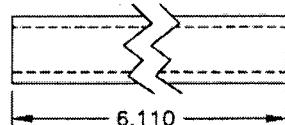


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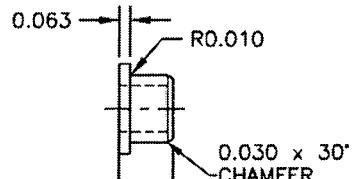
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CHECKED H	APPROVED H	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS	

RELEASED  
04.04.05 H

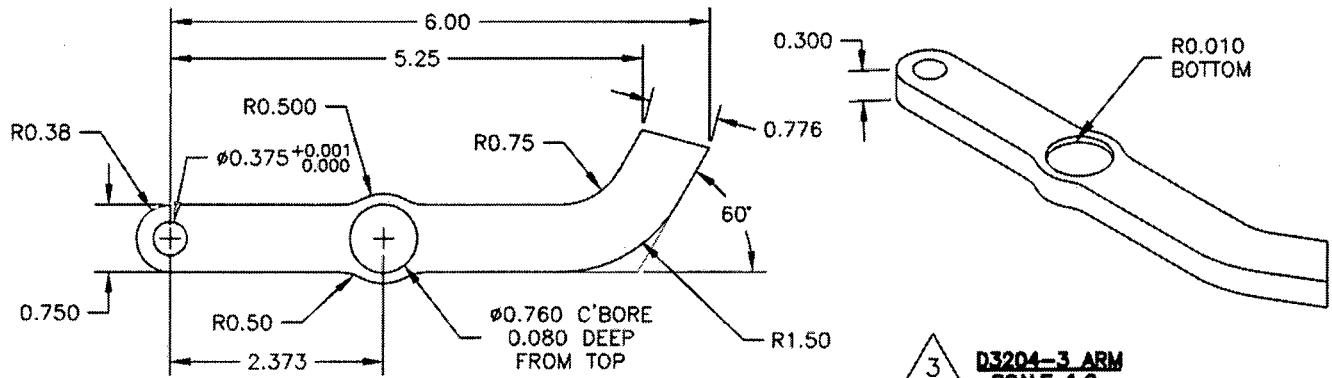
$\phi 0.750$   
 $\phi 0.500$



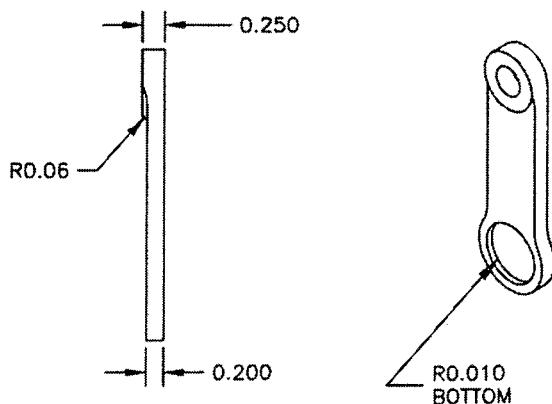
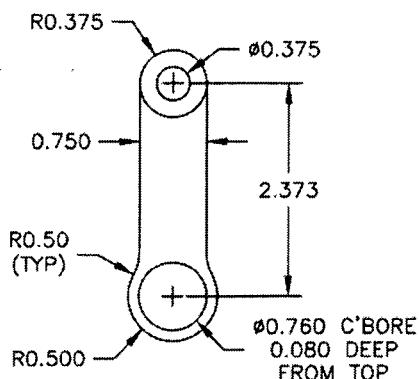
2 D3204-1 TUBE  
SCALE 1:2



4 D3204-7 BUSHING  
SCALE 1:1  
al 04/18/15



3 D3204-3 ARM  
SCALE 1:2  
al 04/18/15



3 D3204-5 ARM  
SCALE 1:2  
al 04/18/15

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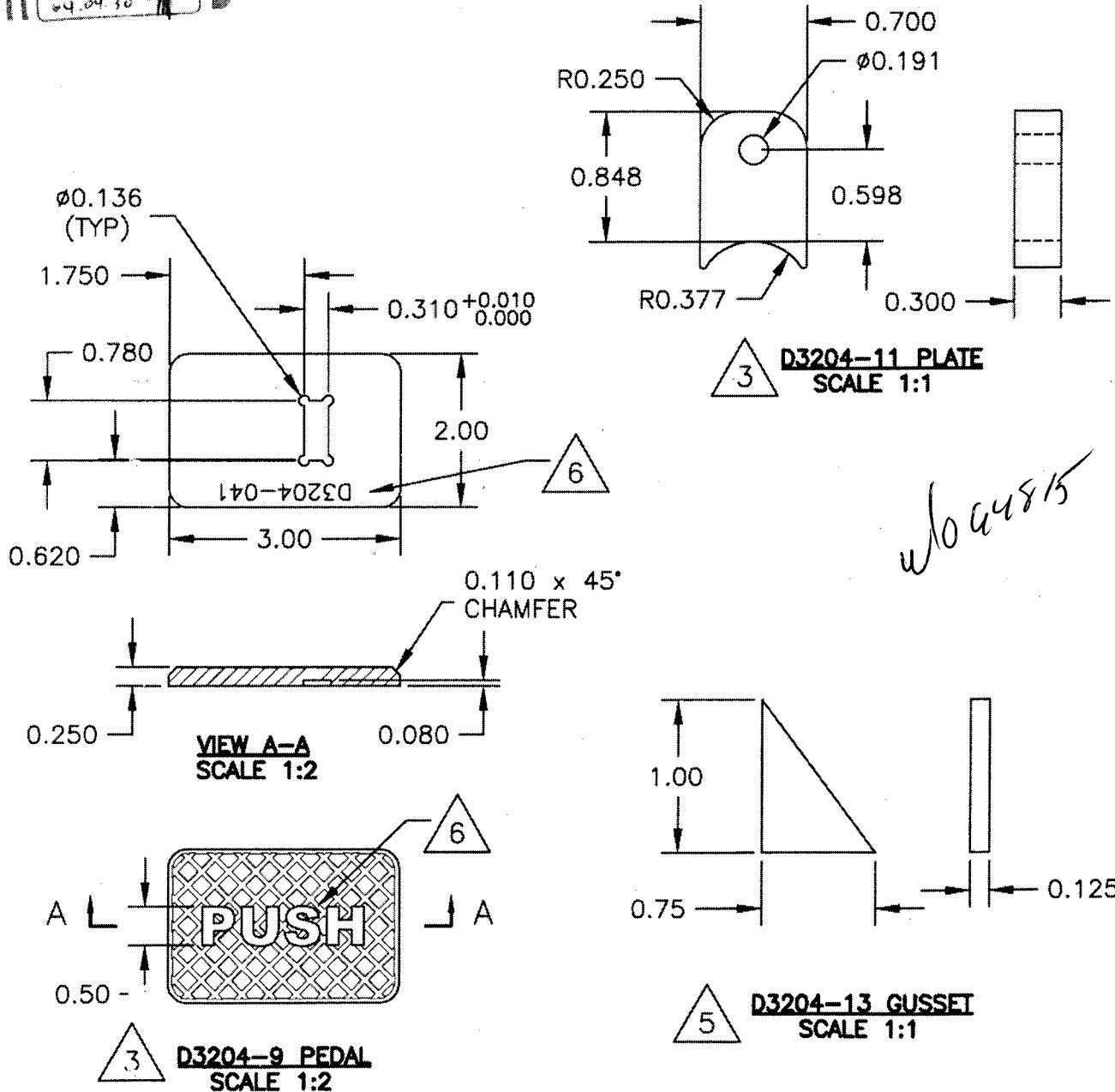
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**DART**

DESIGN <i>RJ</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D3204
DATE 04.01.27		REV. A SHEET 3 OF 3 TITLE RELEASE PEDAL ASSEMBLY SCALE NTS

**RELEASED**  
04.04.30

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